

Date: Thursday, 20/11/2008 3:35:09 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PEDAL
Job Number : 43618	
Estimate Number : 10500	
P.O. Number :	Part Number : D32049
This Issue : 20/11/2008 S.O. No. :	Drawing Number : D3204 REV. A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A1
Previous Run : 38202	Material :
Written By :	Due Date : 21/12/2008 Qty: 10 Um: Each
Checked & Approved By : <u>Julie Dawson 08.11.21</u>	
Comment : Est: C 05.08.11 Added Step 25 KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0375X02000	6061-T6 Bar .375 x 2.00
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Comment: Qty.: 0.2822 f(s)/Unit Total : 1.1290 f(s)
 Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8)
 (M6061T6B0.375x02.000) Batch: 119059
mf 08/11/24 (10)

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut blank: 2.000" x 0.375" x 3.100" long Bar mf 08/11/24 10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 1- Machine as per Folio FA357 and Dwg D3204
 2- Deburr
 Identify as D3204-9 mf 08/11/24 10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE mf 08/11/24 (10)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK mf 08/11/28 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3204-9 PAR #: N/A Fault Category: Prod - NCR: Yes No DQA: 1 Date: 08-12-01
(D412-704-041)
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 1 Date: 08/12/02

NCR: <u>43618</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/11/02</u>	<u>4.0</u>	<u>5 parts scrap. 4</u> <u>disoriented in vice. 1</u> <u>bad origin</u> <u>EC scrap used</u>	<u>CP</u> <u>18.11.28</u> <u>per</u> <u>QD1042</u>	<u>Scrap and</u> <u>Destroy</u> <u>and restore qty (45)</u> <u>B M102057</u>	<u>HP</u> <u>08/11/02</u>	<u>S</u> <u>calculated</u>	<u>CP</u> <u>08.11.28</u> <u>per</u> <u>QD1042</u>	<u>S</u> <u>calculated</u>

NOTE: Date & initial all entries

Date: Thursday, 20/11/2008 3:35:10 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL

Job Number: 43618

Part Number: D32049

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CALL

Be 8/11/28 (10)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/01

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

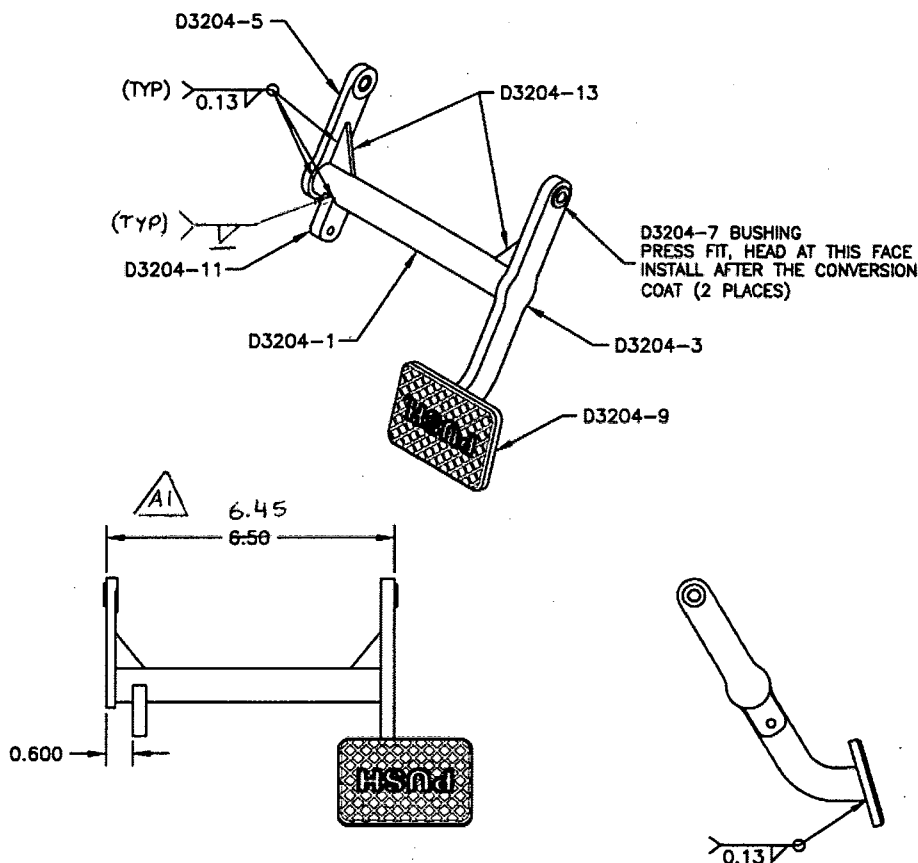
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
AI	05.07.15	6.45 WAS 6.50	

RELEASED
04.04.30



D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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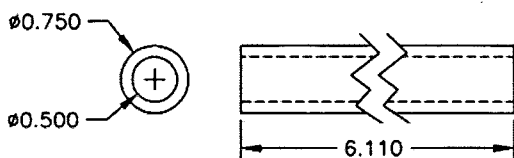
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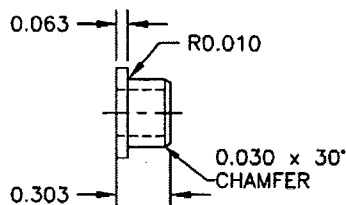


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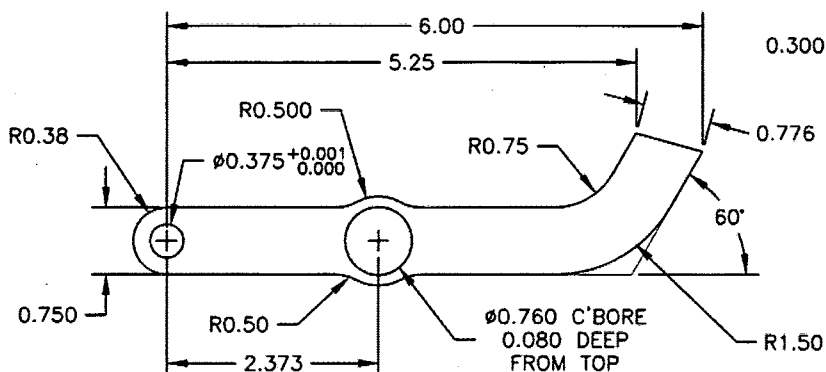
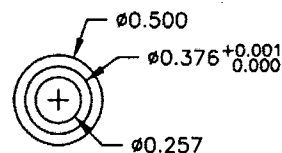
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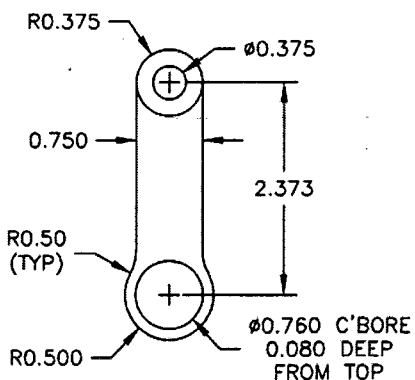
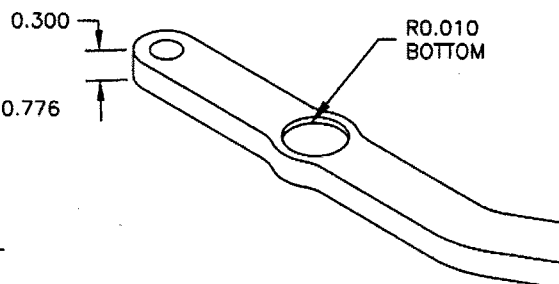
2 D3204-1 TUBE
SCALE 1:2



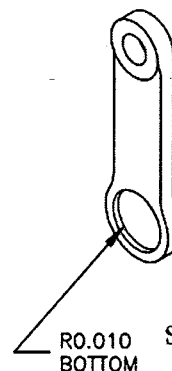
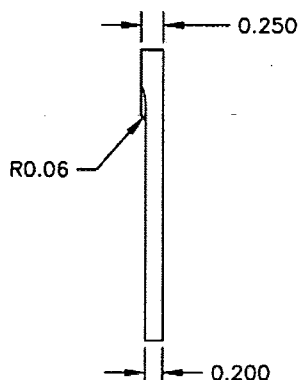
4 D3204-7 BUSHING
SCALE 1:1



3 D3204-3 ARM
SCALE 1:2



3 D3204-5 ARM
SCALE 1:2



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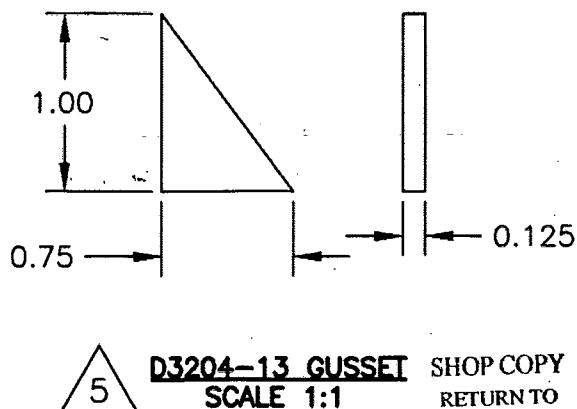
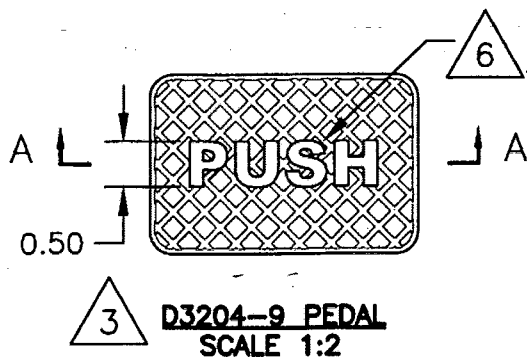
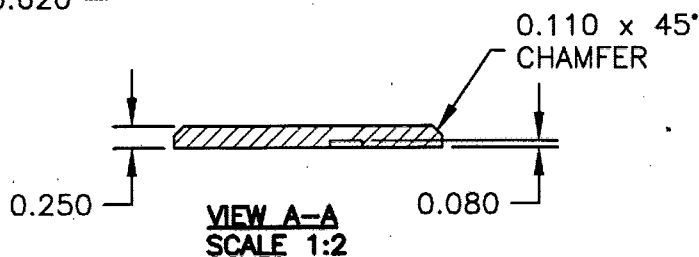
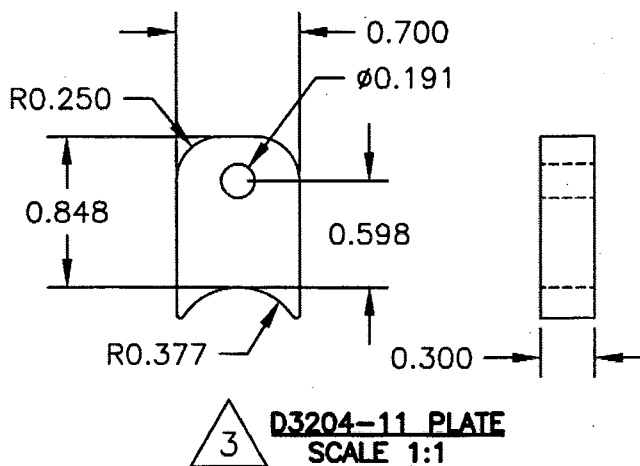
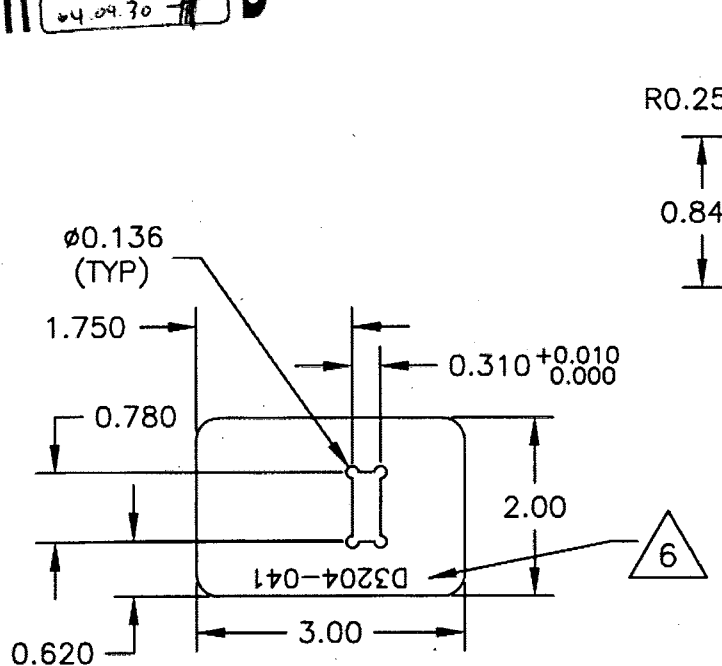
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